

Work Order ID 131186***131186***

Page 1

Monday, March 30, 2015 9:11:23 AM

Item ID: D350-748-203 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: SS Aft Crosstube AS350 / AS355
Start Date: 3/30/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/30/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 1503-30 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-748-243	A								
100	Document Control	0.00							DAS 02 9-89
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD350-748-201		CHG001						
									SEP 22 2015
110	BENDING MACHINE - CROSSTUBES	0.00							
110									
CNC Bend 2	Memo	0.00							
CNC Alpha 160 Bender	Bend tube as per Dwg D350-748-243 using CNC bender program D350A and Folio FT								
	*****UNDER BEND .225" PER SIDE*****								
	*****USE (4) DT9824 SHIM BLOC TO CHECK STRAIGHTNESS*****								

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Item ID: D350-748-203

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: SS Aft Crosstube AS350 / AS355

Stop ***NS2***

Start Date: 3/30/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/30/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
Crosstubes	Memo	0.00							
Crosstubes	****VERIFY CROSSTUBE DIMENSIONS AS PER DWG****								
127	QC15- Crosstube Dimensional Check	0.00							DAS
127									49
QC	Memo	0.00							PD 15-08-10 9-89
Quality Control	***MARK CUT LINES***								
128		0.00							
128									BL 15/08/11
Crosstubes	Memo	0.00							
Crosstubes	CUT TUBE AT HEIGHT ON FAI SHEET								
	VERF HEIGHT <u>31.35</u> BY QC 15 LEVEL INSPECTOR <u>EB</u>								
	VERF TWIST <u>0</u> BY QC15 LEVEL INSPECTOR <u>EB</u>								

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Start Date: 3/30/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/30/2015 Req'd Qty: 1.00 ***1***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Crosstubes	0.00							
130									
Crosstubes	Memo	0.00							
Crosstubes	2- Drill Tube as per Dwg D350-748-243 Using DT8876 Drill Jigs, Set-up drill table as per QSI 010								
	3 -Deburr								
	4- Engrave Part # and Batch # as per Dwg D350-748-243								
	5-Remove all marks from tube within limits of D350-748-243								
140	QC- Inspect dimensions to drawing	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
9
9-89DAS
49
9-89

15/08/21

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

174	Outsource process - NDT per QSI038 4.1	0.00							
174									
Outsource2	Memo	0.00							

Outsource process - NDT ISSUE P/O TO ACCUREN: 29562

176	Receive & Inspect for Damage & Mat'l Certs	0.00							
176									
Packaging	Memo	0.00							
Packaging									

178	QC5- Inspect part completeness to step on W/O	0.00							
178									
QC	Memo	0.00							
Quality Control									

CZ AUG 24 2015 1

AUG 26 2015 DAS 86 9-89

/ DAS 38 9-89
AUG 27 2015

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Item ID: D350-748-203

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: SS Aft Crosstube AS350 / AS355

Start Date: 3/30/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/30/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

0.00

180

SprayPaint

SprayPaint

Spray Painting

Memo

0.00

1-Prime inside and out crosstube as per QSI 005 4.2
BATCH: 132384

POSITIVE RECALL

EFFECTIVE 15-03-30 AUTH W

RELEASED GP DATE 15/04/17

wait for paint scheme

DAS

41

9-89

15-8-25

SEE
Attached

190

QC14- Inspect Spray Paint

0.00

190

QC

Memo

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches

1

JB
15-09-10

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Item Name: SS Aft Crosstube AS350 / AS355

Start Date: 3/30/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/30/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							
Quality Control									

SEP 23 2015

MJS

Picklist Print

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Work Order ID: 131186

131186

Parent Item: D350-748-203

D350-748-203

Parent Item Name: SS Aft Crosstube AS350 / AS355

Start Date: 3/30/2015

Required Date: 3/30/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.03.23 NEW ISSUE DD VERF;JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS51958-63 *MS51958-63* Screw		Purchased	No				Each	50.0000		1		DAS 41 9-89	15-8-31
**													

Location	Loc Qty	Loc Code
ST273	50	
m131886	50	

AN4-41A *AN4-41A* Bolt		Purchased	No			220	Each	229.0000	8	8			
**													

DAS
02
9-89

Location	Loc Qty	Loc Code
ST312A	209	
124836	9	
m130716	192	
m130726	8	
ST340	5	
m124804	5	
ST341	15	
124805	15	

DAS
27
9-89

SEP 15 2015

Picklist Print

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Work Order ID: 131186

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Parent Item: D350-748-203

D350-748-203

Parent Item Name: SS Aft Crosstube AS350 / AS355

Start Date: 3/30/2015

Required Date: 3/30/2015

Start Qty: 1.00

Required Qty: 1.00

AN4-6A Purchased No 220 Each 1,942.000 16 16

AN4-6A

BOLT

DAS
02
9-89

**

Location	Loc Qty	Loc Code
CA	143	
M128403	43	
M130851	100	
ST325A	1599	
M131153	1599	
ST345	200	
M128403	8	
M128634	192	

DAS
27
9-89

AN5-32A Purchased No 220 Each 139.0000 4 4

AN5-32A

Bolt

DAS
02
9-89

**

Location	Loc Qty	Loc Code
ST299A	123	
m130716	23	
m131139	100	
ST336	16	
m128403	7	
m128634	9	

DAS
27
9-89

SEP 15 2015

D3500-1 Manufactured No 220 Each 16.0000 4 4

D3500-1

Saddle

DAS
02
9-89

**

Location	Loc Qty	Loc Code
ST406	16	
125922	5	
129372	11	

DAS
27
9-89

SEP 15 2015

Picklist Print

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Parent Item: D350-748-203

D350-748-203

Parent Item Name: SS Aft Crosstube AS350 / AS355

Start Date: 3/30/2015

Required Date: 3/30/2015

Start Qty: 1.00

Required Qty: 1.00

D3501-1 Manufactured No

220 Each

8.0000

16

16

D3501-1 **DAS**
Bushing **02**
9-89

135919

DAS
6
9-89

DAS
9-89

Location

Loc Qty

Loc Code

ST046

8

125925

1

130742

7

MS21042L4 Purchased No

220 Each

2,634.000

24

24

MS21042L4
Locknut

DAS
27
9-89

DAS
9-89

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

634

m127813

634

ST260a

1056

m130799

56

m131803

1000

ST305

902

426

426

m128300

8

m128798

10

m130922

97

m131340

349

m131618

12

m13030

24

SEP 15 2015

Picklist Print

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Parent Item: D350-748-203

D350-748-203

Parent Item Name: SS Aft Crosstube AS350 / AS355

Start Date: 3/30/2015

Required Date: 3/30/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

220

Each

465.0000

4

4

MS21042L5

Nut

DAS
02
9-89

**

DAS
27
9-89

DAS
8
9-89

Location

Loc Qty

Loc Code

GA

150

m127813

150

ST305

315

m127813

290

m130388

4

m131340

21

~~m130388~~

M132677

4

NAS1149D0463J

Purchased

No

220

Each

2,231.000

32

32

NAS1149D0463J

WASHER

DAS
02
9-89

**

DAS
27
9-89

DAS
8
9-89

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

136

M129390

136

ST269

1698

M130799

507

M131624

1191

M132085

32

SEP 15 2015

Picklist Print

Monday, March 30, 2015 9:11:27 AM

Work Order ID: 131186

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Parent Item: D350-748-203

D350-748-203

Parent Item Name: SS Aft Crosstube AS350 / AS355

Start Date: 3/30/2015

Required Date: 3/30/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

220

Each

799.0000

8

8

DAS

27

9-89

DAS

6

9-89

NAS1149D0563.J

DAS

02

9-89

Washer

SEP 15 2015

Location

Loc Qty

Loc Code

GA

130

m125807

130

ST260a

68

113524

3

118206

2

m130799

63

ST269

156

m128257

156

ST271

445

m131026

445

M132677

8

D350-748-243TRN

Manufactured

No

Each

0.0000

D350-748-243TRN

131189

①

BC 15/08/10

Crosstube Installation, High Aft

D3502-1

Manufactured

No

Each

28.0000

2

DAS

41

9-89

15-9-2

D3502-1

Support

Location

Loc Qty

Loc Code

LG050

28

119578

2

125926

-2

129420

28

2

D5123-7

Manufactured

No

Each

0.0000

2

DAS

41

9-89

15-9-2

D5123-7

Clamp Cushion

131194

2

Picklist Print

Monday, March 30, 2015 9:11:27 AM

Work Order ID: 131186

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Parent Item: D350-748-203

D350-748-203

Parent Item Name: SS Aft Crosstube AS350 / AS355

Start Date: 3/30/2015

Required Date: 3/30/2015

Start Qty: 1.00

Required Qty: 1.00

AETC-1032 Purchased No

Each 20.0000 1

DAS

AETC-1032

41

9-89

15-8-31

Insert

Location

Loc Qty

Loc Code

st549

20

m131156

20

Each

682.0000

1

DAS

41

9-89

15-8-31

NAS1149C0363R

Purchased

No

NAS1149C0363R

Washer

Location

Loc Qty

Loc Code

FP001

120

114742

120

GA

180

m130673

180

ST271

382

m130673

382

Each

157.0000

2

DAS

41

9-89

15-9-2

MS21920-20

Purchased

No

MS21920-20

Clamp

Location

Loc Qty

Loc Code

FG

2

122254

2

LG050

155

m128650

155

2

Item	Qty -243	Part Number	Description
1	X	D350-748-243	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6021-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D5123-7	CLAMP CUSHION
5	1	AETC-1032	INSERT
6	2	MS21920-20 OR MS21920-21/-22	CLAMP (PER DART SPEC. M-MS21920-20/-21/-22)
7	1	NAS1149C0363R	WASHER (OR AN980C10)
8	1	NAS1635-3-8	SCREW (OR MS51958-63)
9	AR	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6021-125
FINISHED LENGTH AFTER TURNING = 124.70±0.06 (AFTER BENDING/TRIMMING = 122.70 REF)
- FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCE: PER DART QSI 018 UNLESS OTHERWISE NOTED.
WALL THICKNESS ECCENTRICITY PER DART QSI 038 7.2
MIN. ALLOWABLE WALL IS -0.020 FROM NOMINAL
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: DART PART NUMBER "D350-748-243" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 8.4 (VIBRATING STYLUS)
- WEIGHT: 29.85 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.290 HOLE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.

TURNING

- BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.

BENDING

- BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES PER SIDE. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 8% BASED ON O.D. ON TOP HALF OF BEND, AND 8% ON BOTTOM HALF OF BEND.
- MAX AMPLITUDE OF RIBBLING ALONG BENT PORTION OF THE TUBE IS 0.030 (ZN A1-3)
- MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.38 (ZN C1-3).

ASSEMBLY

- TO INSTALL D3502-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.02" TO 0.05" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- TORQUE CLAMPS 80 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

N. 131186 HCT
1503-30

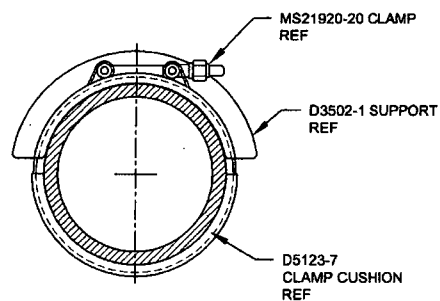
RELEASED

2015 MAR 18

4/ ECU 15-547

A	NEW ISSUE	CP	15.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	Q	DART AEROSPACE LTD	
DRAWN	Q	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	D350-748-243	SHEET 1 OF 4
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	15.01.21	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**D350-748-243
ASSEMBLY DETAIL**



SECTION A-A D4-2
SCALE 6X

INSTALL THIS SIDE ONLY, AFTER FINISH:
AETC-1032 INSERT
NAS1149C0363R WASHER
NAS1635-3-8 SCREW

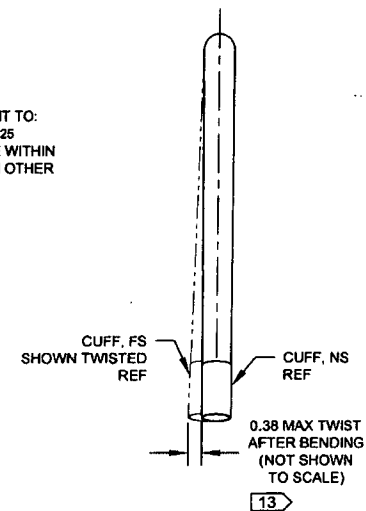
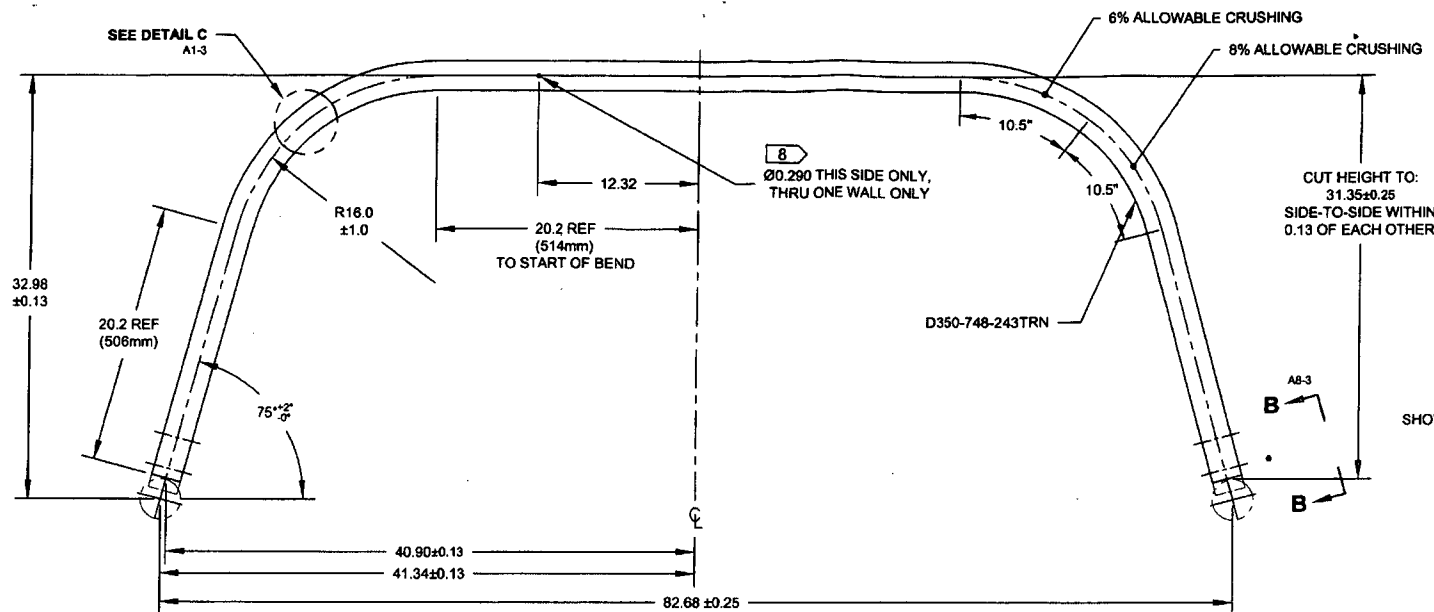
14 15
D3502-1 SUPPORT
MS21920-20 CLAMP (OR -21/-22)
D5123-7 RUBBER CUSHION
2 PL

D350-748-243
BENT TUBE

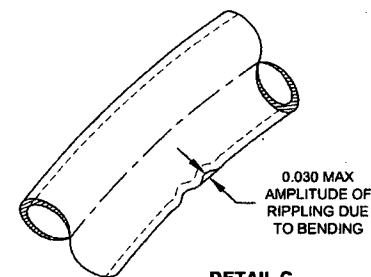
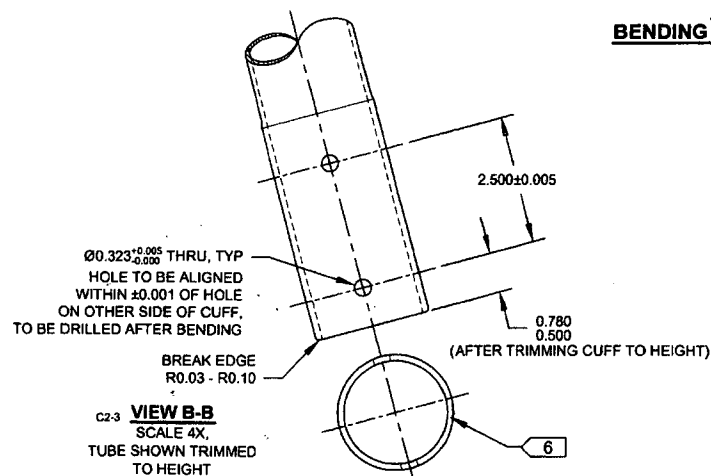
RELEASED

2015 MAR 18

DESIGN	g	DART AEROSPACE LTD	
DRAWN	g	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D350-748-243	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	15.01.21	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



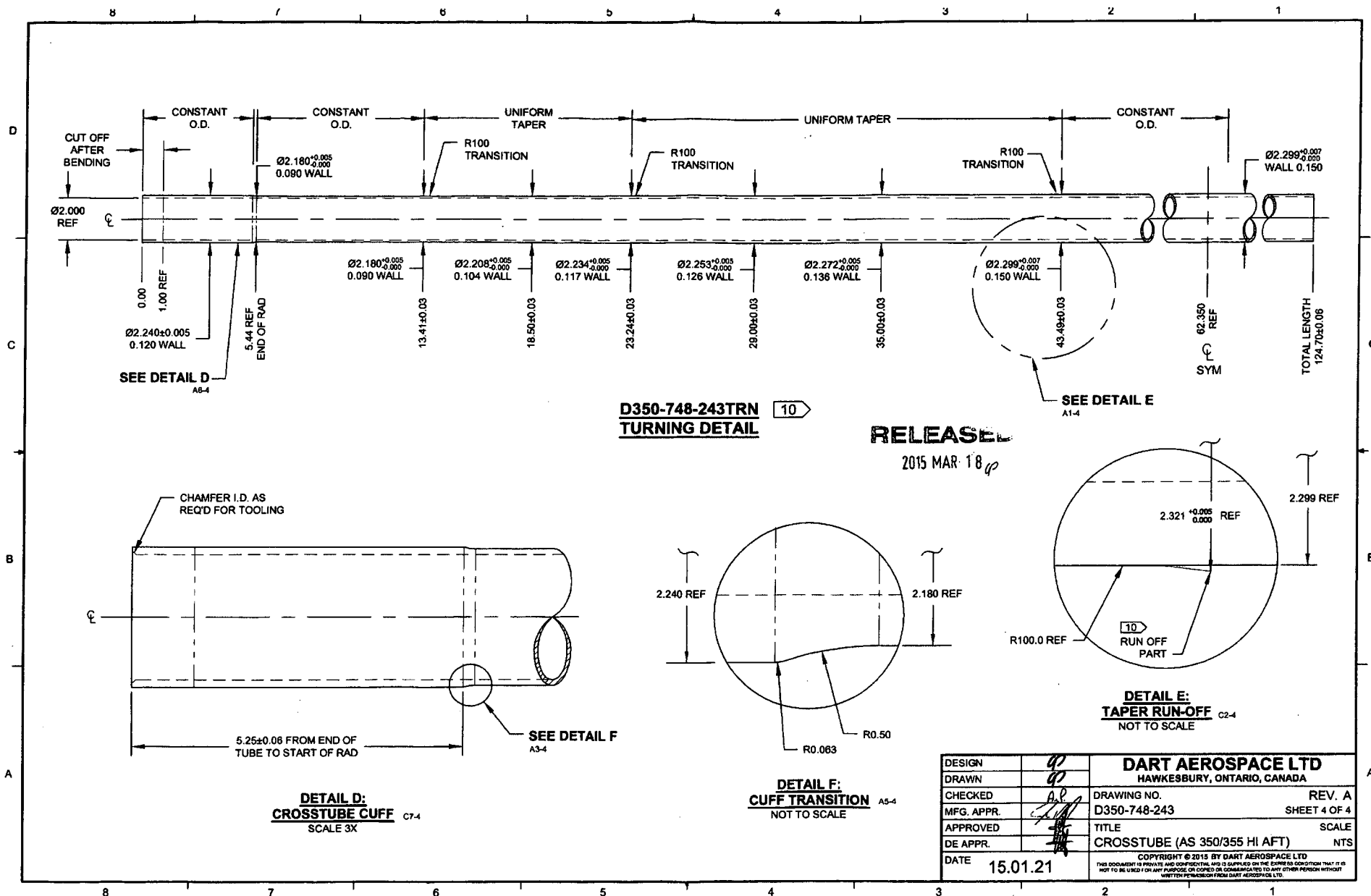
**D350-748-243
BENDING AND DRILLING DETAIL** 11



DETAIL C D7-3
SCALE 4X
RIPPLING EXAGGERATED

RELEASED
2015 MAR 18

DESIGN	9	DART AEROSPACE LTD	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D350-748-243	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI AFT)	NTS
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skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO25564	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 29562
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

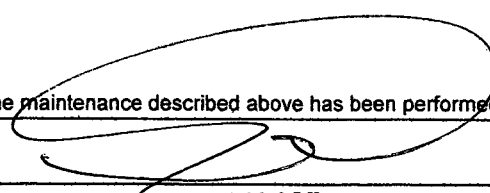
CARRY OUT NDT ON 9 CROSSTUBES AS PE PO29562

3 SSFWD CROSSTUBES , ITEM ID# D350-748-103 , WORK ORDER ID# 131170, 131171, 131173

6 SS AFT CROSSTUBES , ITEM ID# D350-748-203 , WORK ORDER ID# 131182, 131183, 131184, 131185, 131186, 131187

Action Taken:					Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, UV M-20141, CLEANER SKC-S MPO13923 , DEV. MPO11715					AUG 24 2015	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: AUG 24 2015
Name: RAFFA DELICIA		

DUA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☒</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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To increase adhesion of prime/paint, use the following: Arcite 1320SS cleaner Arcite 230S Metaklok. Tests show that Arcite provides superior adhesion vs normal procedure per QSI 005				Arcite 1320S Cleaner: 132520 B/N Arcite 230S Metaklok: 132474 B/N																																																																					
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4.0 WEIGHT AND BALANCE

The following weight and balance information is for Dart crosstube installations only. This data should be similar to the existing installation. Differences from the parts removed are the responsibility of the installer.

DART CROSSTUBE	FWD/ AFT	WEIGHT	STA	MOMENT
D350-748-101 D350-748-103	Fwd	35.2 lb (16.0 kg)	106.3 in (2.70 m)	3742 lb-in (43.2 kg-m)
D350-748-201 D350-748-203	Aft	34.7 lb (15.7 kg)	162.4 in (4.12 m)	5635 lb-in (64.7 kg-m)

5.0 PARTS LIST

Qty -101	Qty -103	Qty -201	Qty -203	Part Number	Description
X				D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X			D350-748-103	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD (SS)
		X		D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
			X	D350-748-203	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT (SS)
1				D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1			D350-748-143	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD (SS)
		1		D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
			1	D350-748-243	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT (SS)
*2	*2	*2	*2	D3502-1	SUPPORT
*2	*2	*2	*2	D5123-7	CLAMP CUSHION
*1		*1		AELS-1032-225	INSERT
	*1		*1	AETC-1032	INSERT
*2	*2	*2	*2	MS21920-20	CLAMP (OR MS21920-21/-22)
*1		*1		MS27039-1-10	SCREW
	*1		*1	NAS1685-3-8	SCREW (OR MS51958-63)
*1		*1		NAS1149D0363J	WASHER (OR AN960JD10)
	*1		*1	NAS1149C0363R	WASHER (OR AN960C10)
4	4	4	4	D3500-1	SADDLE
16	16	16	16	D3501-1	BUSHING
16	16	16	16	AN4-6A	BOLT
8	8	8	8	AN4-41A	BOLT
4	4	4	4	AN5-32A	BOLT
32	32	32	32	NAS1149D0463J	WASHER (OR AN960JD416)
8	8	8	8	NAS1149D0563J	WASHER (OR AN960JD516)
24	24	24	24	MS21042L4	NUT (OR MS21042-4)
4	4	4	4	MS21042L5	NUT (OR MS21042-5)

* REFERENCE ONLY. PARTS ARE INCLUDED IN D350-748-141/-143/-241/-243 ASSEMBLIES ABOVE

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X				D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X			D350-748-103	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD (SS)
		X		D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
			X	D350-748-203	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT (SS)
1				D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1			D350-748-143	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD (SS)
		1		D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
			1	D350-748-243	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT (SS)
*2	*2	*2	*2	D3502-1	SUPPORT
*2	*2	*2	*2	D5123-7	CLAMP CUSHION
*1		*1		AELS-1032-225	INSERT
	*1		*1	AETC-1032	INSERT
*2	*2	*2	*2	MS21920-20	CLAMP (OR MS21920-21/-22)
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	*1		*1	NAS1149C0363R	WASHER (OR AN960C10)
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16	16	16	16	D3501-1	BUSHING
16	16	16	16	AN4-6A	BOLT
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